Each

Thursday, 16/08/2007 11:31:57 AM Date User Linda Lacelle **Process Sheet** : STEP EXTRUSION : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Jot Number : 34016 -1 Est mate Number : 10058 : D2622120C P.C. Number : HIA Part Number S.O. No. : N/A : D2622 REV C1 : 16/08/2007 **Drawing Number** This Issue : N/A Prsht Rev. : NC Project Number : MA Type : PURCHASED PARTS : C1 First Issue **Drawing Revision** : 32858 Material Previous Run : NIA : 10/09/2007 **Due Date** Written By Checked & Approved By Comment KJ/RF **Additional Product** Jot Number: Machine Or Operation: Description: Seq. #: PURCHASING 1.0 CL67/06/16 Comment: PURCHASING Issue P/O: a) Extrude as per Dwg D2622 Rev. C b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 8% f) Order at 120" longg) Bon L Canada Inc. tool # 897123 Rev. A h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required 2.0 D2622120CP Extrusion Comment: Qty.: 1.0000 Each(s)/Unit Total: 110.0000 Each(s) Extrusion 3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0 QC6



Comment: DIMENSIONAL CHECK

Inspect dimension per Dwg D2622

Check Pull test per Dwg D2622 for compliance page attached

Check hardness with Webster tester





Dart Aerospace Ltd

V#/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	- 31	PAR #: Fault Category: NC	R: Yes	No DQA	1:5	Date:	27/09/19

QA: N/C Closed: ____ Date: ____

NCR:		W	ORK OR	DER NON-CONFORMANCE	(NCR)			
NOIX.								
DATE	STEP	Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng			Section C	Chief Eng	QC Inspector
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THE PAR	Fall							(WII 11
Hart :								
The same								
								- 4
	装车							
18.4								

NOTE: Date & initial all entries

* Thursday, 16/08/2007 11:31:57 AM Linda Lacelle User: **Process Sheet** Drawing Name: STEP EXTRUSION Customer: CU-DAR001 Dart Helicopters Services Job Number: 34016 Part Number: D2622120C ob Number: Seq. #: Machine Or Operation: Description: PACKAGING 1 PACKAGING RESOURCE #1 5.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: UA QC21 FINAL INSPECTION/W/O RELEASE 6.0 90 Comment: FINAL INSPECTION/W/O RELEASE N 8709-19 Job Completion

Dart Aerospace Ltd

VM/O:			V	ORK ORDER CHANG	ES					Y
DATE	STEP	PROC	EDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	NCR:	Yes	No DQA	:	Date:			
				QA: N	/C Closed	:	_ Date: _	F = 1		
NCR:		W	ORK OR	DER NON-CONFORMA	NCE	(NCR	2)			
DATE	STEP	Description of NC	Corrective Action Section B			Verificat				Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector
1.00										

NOTE: Date & initial all entries



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	DESIGN KE		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
	CHEC	KED	APPROVED	DRAWING NO. REV. C D2622 SHEET 1 OF 1
	DATE 02.09,11			STEP EXTRUSION 1:1
	Α		96.11.29	NEW ISSUE
	В		97.12.12	CHANGE MATERIAL, ADD TOL. QSI
	С		02.09.11	0.080 WAS 0.085; ADD PART & DIE No.
8	CI	A	02 10 64	APP 'REV A' TO DIE NUMBER

SELEASED

		1 114 -1			
	-	3.000			
-			- F	RO.285	
0.958			-	0.080	
2.500					
		1	//- F	R2.085 - 0.248 (REF)
,	60.4* (REF)		45		, ,
	7	<u>Ç</u> 1.193	RO.5		201 0202
		1.874 (REF) —	-	w/0:	34016

D2622-XXX STEP EXTRUSION

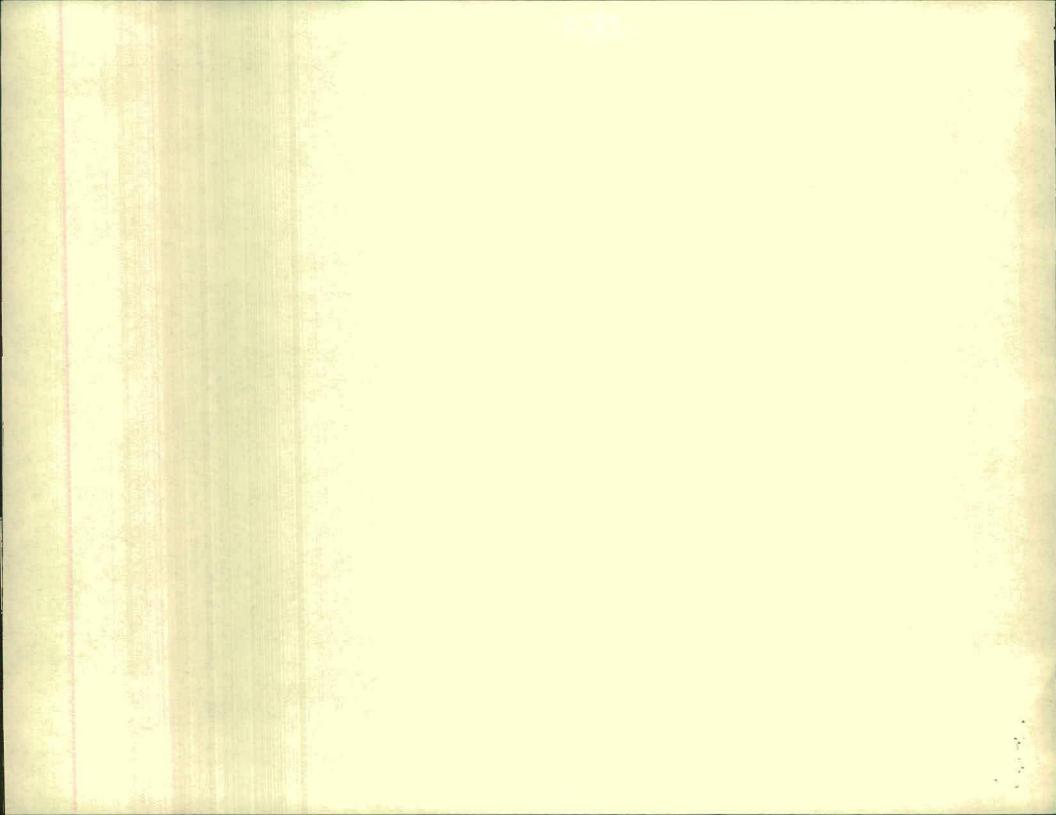
- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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BON L CANADA INC.

1777

SUBSIDIAPIES OF TREDEGAR CORPORATION FILIALES DE LA CORPORATION TREDEGAR

ORDER DATE

DATE DE LA COMMANDE 08/18/07

SHIP TO/EXPÉDIÉ À

IAMKESBURY

USTOMER IDAN" DU CLIENT

65024

66 1K7

MARY AEROSPACE L'TL.

HOWE 613-632-5200

270 APERDIEN ST

ACCIN 00044024

THE WILLIAM L. BONNELL COMPANY, INC.

SOLD TOVENDU À

N 44 1 187

CUST, P.O. NO. Nº DE COMM. DU CLIENT JOB/PROJET

DART MERONOVACE LINE

HUNE 513-830-5200

1270 AEEROCEN ST.

INVOICING COMPANY AND LOCATION BUREAU DE FACTURATION

CONT L CAMATA THE

TOOL EDWARD AVENUE

RICHMUND HIL ON

SHIPPING MANIFEST BORDEREAU D'EXPEDITIC

MANIFEST DATE/DATE D'EXPÉDITION

MANIFEST NUMBER/Nº D'EXPÉDITION REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE.
REFEREZ-VOUS À CES

SALES ORDER NUMBER/N° DE COMM.

SALES REP REP. DES VENTES

CUST SERVICE REP

CREDIT REP

REP DU CRÉDIT

650-635-6551

NUMEROS POUR TOUTE CORRESPONDANCE.

905-508-3250

FIELD SALES REP

LOC/USINE TRAILER NO /N' DE REMORQUE SALESMAN/VENDEUR

50358

BILL OF LADING NUMBER/N° DE CONNAISSEMENT

独门了下来

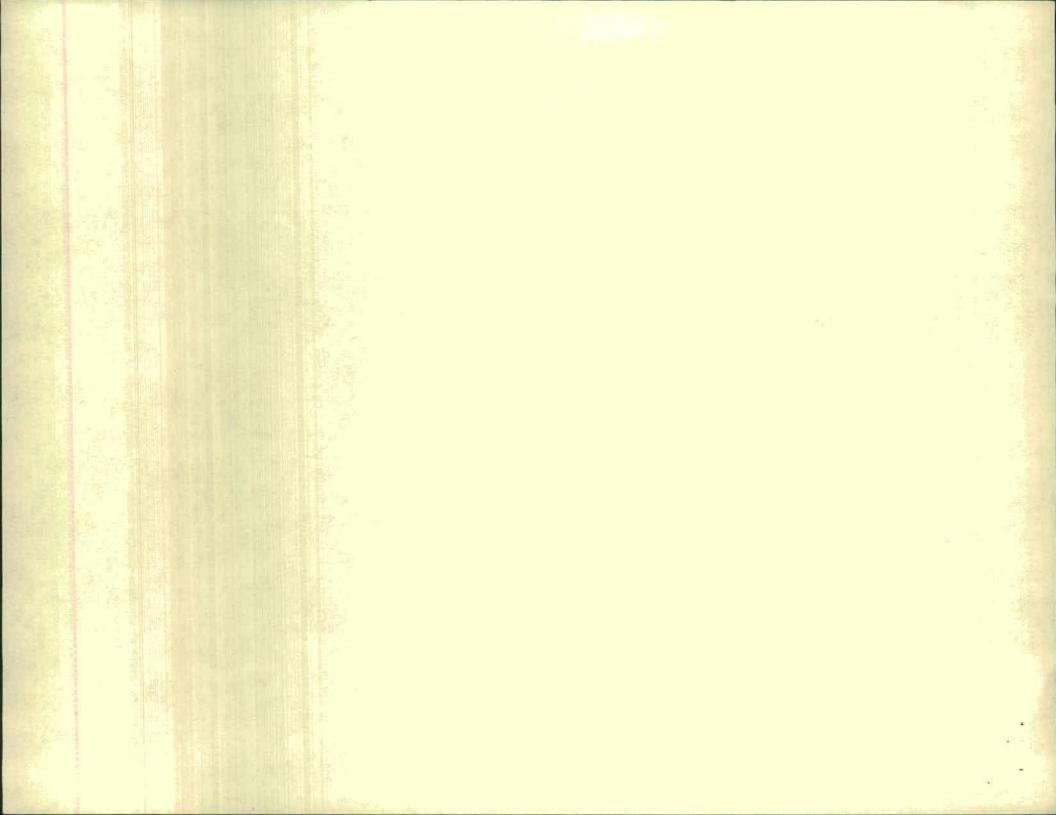
0.04 电线键

00355490

REP. REGIONAL DES VENTES REP. SERVICE CLIENTÈLE

905-427-2227

ITEM I	ORDER QUANTITY UNIT SHIPPED OTY.		UNIT SHPPED OTY. UNITE OTE DEJA EXPÉDIÉE Nº DE PIÈCE DU CUENT LONGUEUR CUTTING TOLERANCE		FINISH DESCRIPTION DESC. DE LA FINITION FARBICATION DESCRIPTION		THIS SHIPMENT/CETTE EXPÉDITION			OHANTITY D	
NO. PITEM	ORDER QUANTITY QTE COMMANDÉE	UNITE	OTÉ DÉJA EXPÉDIÉE	CUSTOMER PART NUMBER NUMÉRO DE PIÈCE DU CLIENT	CUTTING TOLERANCE TOLERANCE DE COUPE	FABRICATION DESCRIPTION TYPE DE FABRICATION SHIPPING TOLERANCE TOLERANCE D'EXPÉDITION	NO. PKGS. N° DE PAQUETS	GROSS WT. POIDS BRUT	NET WT. POIDS NET	UNIT	QUANTITY DI QUANTITÉ PRÉ
01	1.21	PC M	0	PA - 877123-1	6041 774 126 - 13715 *	FILE DERTIFICATE OF COMP +015-015.0139-0102		578	402.34 132	KO M	
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BON L CANADA INC

500 EDWARD AVENUE RICHMOND HILL, ON L4C 4Y9

CERTIFICATE OF COMPLIANCE

Cart Date	Cars No	Sales Order	Page
08/28/07	165105	82904	1
Cust PO	B/L No	Lot	Date
4375	00355495	82904010	8/28/07

DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Shin To DART AEROSPACE LTD. 1270 ABERDEEN ST.

HAWKESBURY, ON K6A 1K7

Item No	Part No 1	tem Description	and the second second	Cust Part
1.000	DAA-897123-1	120" Mill 6061 T6		D2622
Gross Weight	578 KG	S		part (Herris Sand)
Net Oly	536 KG	132 PC	402 M	3 PKG

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.00

AMS-QQ-A-200/8 & ASTM B221-00

Mecha	nical	Tests:											-
Test	Te	nsile		Y	ield						Be	nd/	
No.	MPA	/ KSI		MPA	/ KSI	2	Elonga	tion	Cond	uctivi		ift HREW	P.
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	cal Ana	arysis											
SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER	
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This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

D. VanBakel, QA Manager Signed for Bon L Canada

